

January-26-12 1:10:12 PM

**\*79482\***

Page 1

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Item Name:** Spacer

**\*10\***

**Cust Item ID:**

\*10\*

**Customer:**

**Reference:**

Approvals: Process Plan: M.L.J

Date: 12/01/20

**Tooling:**

Date:

Run Start \*NR1\*

QC:

Date:

**SPC (Y/N):**

Date:

Stop \*NR2\*

<b>Draw Nbr</b>	<b>Revision Nbr</b>
D2525	Rev B

0.00

**\*100\***

### CONVENTIONAL LATHE

Lathe Conv

## Memo

0.00

### Conventional Lathe

Turn as per Dwg D2525

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

## Memo

0.00

## Quality Control

120

QC8- Inspect parts - second check

0.00

\*120\*

## Memo

0.00

OC

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 79482

**\*79482\***

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January-26-12 1:10:12 PM

Item ID: D2525-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Spacer  
 Start Date: 26/01/2012 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 09/02/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*130*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>10</u>	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									

*10 BL 12-2-2.*

*10X of M-12/02/02*

*12/12/02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 79482****\*79482\***

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Item ID: D2525-1      Accept      **\*N900040100\***      Setup      Start      **\*NS1\***  
Revision ID:      Stop      **\*NS2\***  
Item Name: Spacer  
Start Date: 26/01/2012      Start Qty: 10.00      **\*10\***      Cust Item ID:  
Required Date: 09/02/2012      Req'd Qty: 10.00      **\*10\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run      Start      **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop      **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

Handwritten: 425 12/02/03 [Signature]

Handwritten: P/2022 [Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 79482

\*79482\*

Parent Item: D2525-1

\*D2525-1\*

Parent Item Name: Spacer

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP B99.11.10Re-format added Acid etch stepEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	34.6390	0.0625	0.657895			

\*M6061T6R0 750\*

\*\*

6061-T6 Round Bar .750"

Location	Loc Qty	Loc Code
MAT013	34.639	
112442	0.796	
117481	1.969	
118106	1.338	
119231	6.536	
119613	24	

1.8 ~~AD~~ 12/02/01

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

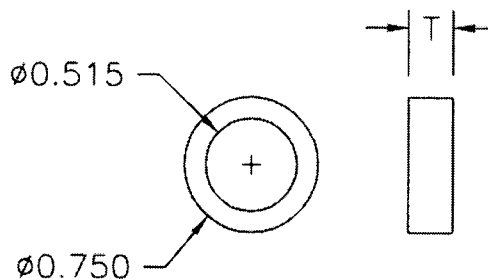




DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED RF	DRAWING NO. D2525	REV. B SHEET 1 OF 1
DATE 99.09.30		TITLE SPACER KIT SCALE 1:1	
A	95.12.22	NEW ISSUE	
B	99.09.30	REVISED MATERIAL	

RELEASED  
99.10.12 KE

PART NUMBER	THICKNESS T	QTY
D2525-1	0.750	1
D2525-3	0.250	1
D2525-5	0.125	4
D2525-7	0.063	0
D2525-9	0.032	0



STRICTLY COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 79482 M.C.J.  
12/01/26

MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1)  
OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# FIRST ARTICLE INSPECTION CHECKLIST

DART AEROSPACE LTD		Work Order:	79482
Description:		Part Number:	2525-1
Inspection Dwg:		Rev:	2525 Rev: B
Page 1 of 1			

Drawing	Dimension	Tolerance	Actual	Dimension	Accept	Reject	Method of Inspection	Comments
0.515	±.006	±.010	0.519	0.753	—	—	RA26	Vem
0.750	±.010	±.010	0.753	0.753	—	—	11	
1.750	±.010	±.010	1.753	1.753	—	—	11	

☒ First Article
 ☒ Prototype

Measured by:		Audited by:	
Date:	12/02/01	Date:	12/2/01
Rev	A	Revised by	KJ/JLM
Date	Change	Approved	
New Issue			